

Date: Tuesday, 06/02/2007 8:52:11 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 30666  
 Estimate Number : 10997  
 P.O. Number : N/A  
 This Issue : 06/02/2007 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : N/A Type : MACHINED PARTS  
 Previous Run : 29327  
 Written By :  
 Checked & Approved By :  
 Comment : Est. B02.11.28 Reformat KJ

Drawing Name : 350 SKIDTUBE EXTRUSION (BENT)  
 Part Number : D26003BENT  
 Drawing Number : D2600 D1/D2750 D  
 Project Number : N/A  
 Drawing Revision : D1/D  
 Material : N/A  
 Date : 19/02/2007 Qty: 100 Um: Each

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description :   |           |             |             |       |   |         |           |           |
|---------|-----------------------|---|-----------|-------------|-------------|-------|---|---------|-----------|-----------|
| 1.0     | D26003120             | Extrusion Round 3" 350<br>  |           |             |             |       |   |         |           |           |
|         |                       | Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)<br>Extrusion Bent<br>Pick:<br><table> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D2600-3</td> <td>Extrusion</td> <td>B26205X38</td> </tr> </tbody> </table> | Qty       | Part Number | Description | Batch | 1 | D2600-3 | Extrusion | B26205X38 |
| Qty     | Part Number           | Description   | Batch     |             |             |       |   |         |           |           |
| 1       | D2600-3               | Extrusion   | B26205X38 |             |             |       |   |         |           |           |
| 2.0     | BENDING               | BENDING MACHINE<br><br>Comment: BENDING MACHINE<br>Deburr one end of extrusion<br>Drill #30 pilot holes using DT8689<br>Open holes to 5/16" and deburr<br>Bend using CNC bending machine as per program 2750.C and Folio FT003.<br>Use 5/16 locator pin on buggy "A".<br>Check fit to Jig DT8150<br>      |           |             |             |       |   |         |           |           |
| 3.0     | QC5                   | INSPECT WORK TO CURRENT STEP<br><br>Comment: INSPECT WORK TO CURRENT STEP<br>Inspect work to Step 6 Ensure fit to Jig DT8150<br>  |           |             |             |       |   |         |           |           |
| 4.0     | PACKAGING 1           | PACKAGING RESOURCE #1<br><br>Comment: PACKAGING RESOURCE #1<br>Identify and Stock<br>Location: LG<br>   |           |             |             |       |   |         |           |           |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/03/03  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE EXTRUSION (BENT)

Job Number: 30666

Part Number: D26003BENT

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |      |                              |
|-----|------|------------------------------|
| 5.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
|-----|------|------------------------------|



38

Comment: FINAL INSPECTION/W/O RELEASE

38  
C7103 123

Job Completion

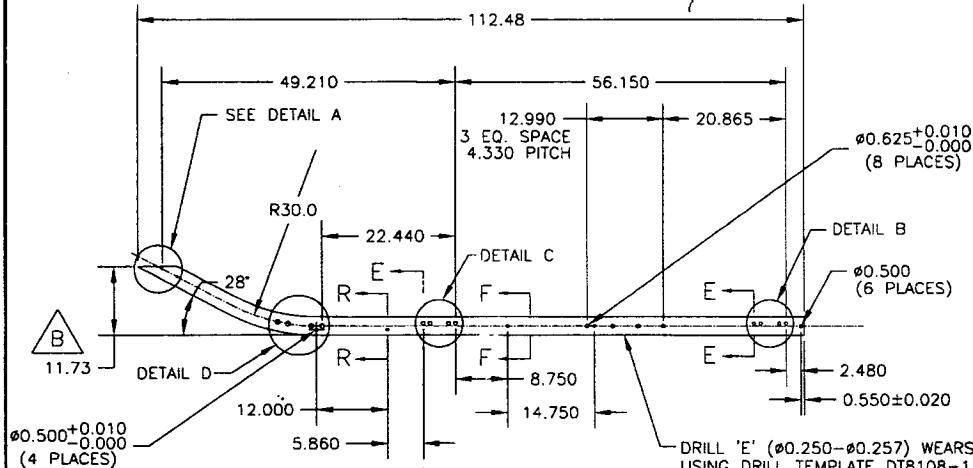


il 07/03/22

2  
99905  
JM  
UNDER REVIEW

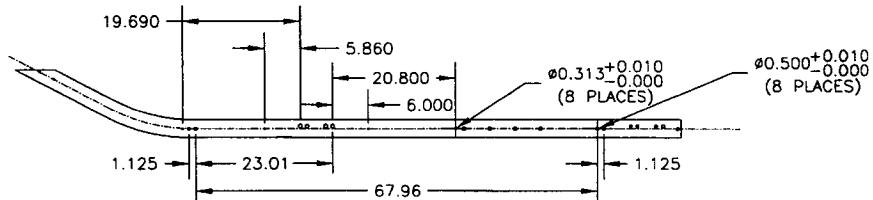
07.02.07 18

SS wearplates



DRILL 'E' (0.250-0.257) WEARSHOE HOLES  
USING DRILL TEMPLATE DT8108-1  
PER SECTION F-F (42 PLACES).  
USE DT8108-2 FOR D2750-2.  
C'SINK Ø.391X100' WEARSHOE HOLES  
(38 PLACES)

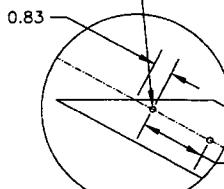
DO NOT C'SINK D3488-041/-042 HOLES



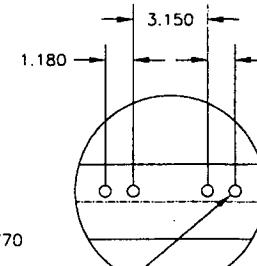
D2750-3/-4 AND D2750-1/-2 HAVE THE SAME SADDLE AND  
GROUND HANDLING HOLES

DRILL 'E' (0.250-0.257)

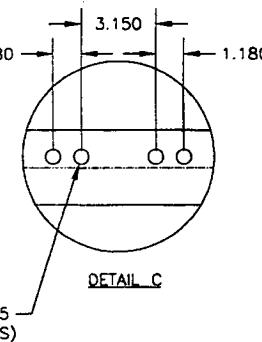
C'SINK Ø.291X100'  
(4 PLACES)



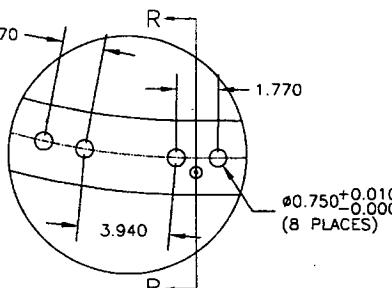
DETAIL A



DETAIL B



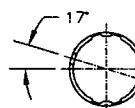
DETAIL C



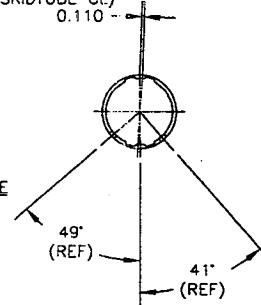
DETAIL D  
(ALL DIMENSIONS ARE  
STRAIGHT LINE DIMENSIONS)

(FROM WEARSHOE CL  
TO SKIDTUBE CL)

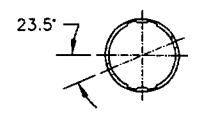
0.110



SECTION E-E



SECTION F-F



SECTION R-R

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DART AEROSPACE USA, INC.  
PORT HADLOCK, WA

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CHECKED

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PH

DRAWING NO.

D2750

SHEET 3 OF 5

DATE

06.01.05

TITLE

350 SKIDTUBE ASSEMBLY

1:20